

Claims

1. A coated cutting tool insert of cemented carbide with a coating including at least one layer of $Ti_{1-x}Al_xN$ deposited by PVD-technique c h a r a c t e r i s e d in
5 that $x=0.4-0.6$ with a compressive residual stress of $>4-6$ GPa and a thickness of $1.5-5$, preferably $2.5-4$, μm ; both the intensities of the (111) and (200) reflections, $I(111)$ and $I(200)$, are <7.5 , preferably <5 times, the intensity average noise level.
- 10 2. Method of making a coated cutting tool insert of cemented carbide with a coating including at least one layer of $Ti_{1-x}Al_xN$ deposited by PVD-technique c h a r a c t e r i s e d in depositing the layer with a bias, U , in the range $-90 < U < -50V$, preferably $-80V < U < -$
15 $60V$; with a nitrogen pressure in the range of $20-40$ μbar ; arc current in the range $160-220$ A and temperature in the range $400-600$ $^{\circ}C$.